

Date: Wednesday, 18/02/2009 2:47:30 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 44684	
Estimate Number : 13131	
P.O. Number :	Part Number : D36873
This Issue : 18/02/2009 S.O. No. :	Drawing Number : D36874 <i>rev B</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : 12/01/2009 Type : PURCHASED PARTS	Drawing Revision : U/R
Previous Run : 36809	Material :
Written By :	Due Date : 23/02/2009 Qty: 6 Um: Each
Checked & Approved By : <u>C209102/119</u>	
Comment : Est Rev:A New Issue 08-01-15 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH
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**Comment:** Sub-Contracting ship mat'l to MetcorP.O. 7972 8148 C209102/105 ~~8148~~

M174B3937X4750 for heat treating
 to condition H900 (to become M174PHH900B3937X4750)
 FTU in excess of 190ksi
 FTY in excess of 170ksi
 certificate required

2.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O for D3687-3P P.O. 7972 C209101/14 (6)
 Machine as per Dwg D3687 Rev. B
 Possible Supplier: Globus Precision
 Conformity sheet required
 Ship to supplier:
 M174PHH900B3937X4750 B m110875

3.0	M174B3937X4750	17-4 SS Bar 3.937 x 4.750
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Comment: Qty.: 0.3500 f(s)/Unit Total: 2.0998 f(s)
 17-4 SS Bar 3.937 x 4.750

Date: Wednesday, 18/02/2009 2:47:31 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 44684

Part Number: D36873

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D36873P

MOUNT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
MOUNT

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure certificate of conformity is attached

6/4/4/3

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

508/04/08

XL

7.0

OUTSIDE SERV.30

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting OUTSIDE SERVICES-MACH
Issue P/O: 8537
LPI Per ASTM 1417 LEVEL 2
Certificate of conformaty is required

C209/04/09

6

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
RECEIVE AND INSPECT FOR TRANSIT
DAMAGE
ENSURE C OF C ATTACHED

12/9/09

6

9.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

508/04/08

XL

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 123

9/4/9

50
6

Date: Wednesday, 18/02/2009 2:47:31 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 44684

Part Number: D36873

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



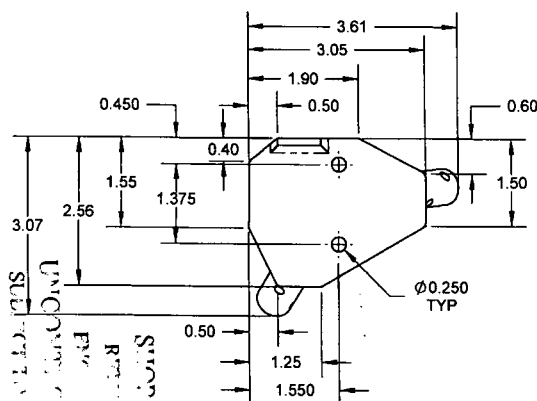
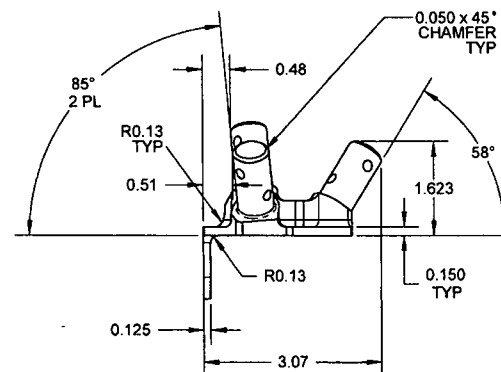
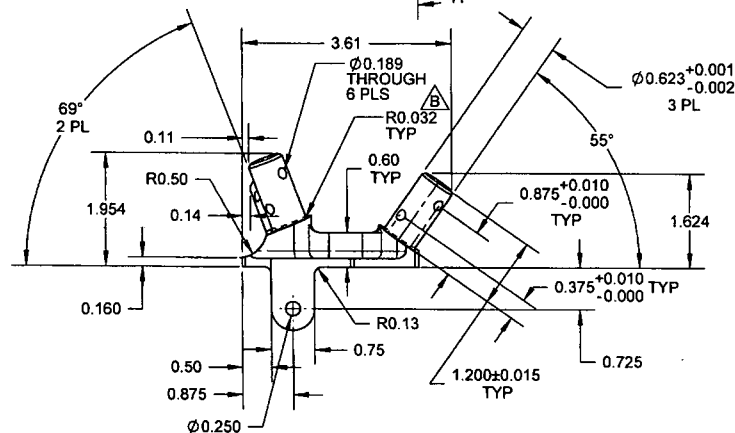
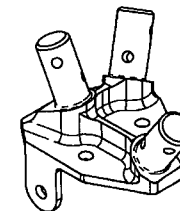
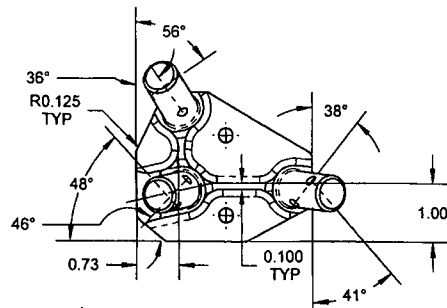
09/04/14 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 09.04.14



D3687-1 MOUNT



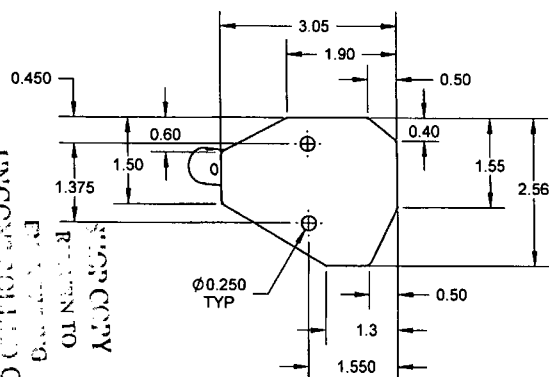
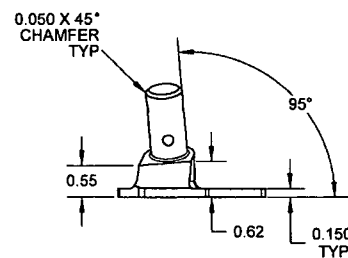
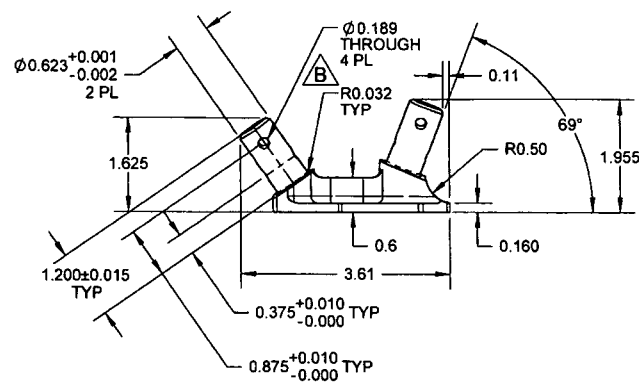
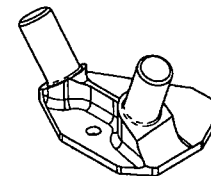
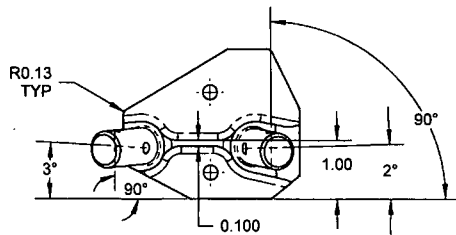
- NOTES:**
- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.81 lb
 - 8) LPI PER ASTM 1417 LEVEL 2

RELEASED
08/12/15

B	CHANGE TO 17-4PH H-900 (ZN A6-1 & B3-2); R0.032 WAS R0.015 (ZN C7-1 & C7-2); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3687	SHEET 1 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MOUNT	NTS
DATE	08.11.24	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

NO 141081

8 7 6 5 4 3 2 1



- NOTES:**
- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.64 lb
 - 8) LPI PER ASTM 1417 LEVEL 2

RELEASED
08/12/15

D3687-3 MOUNT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3687	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 2	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MOUNT	NTS
DATE	08.11.24	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

NO 24684
UNCONTROLLED COPY
SUBJECT TO
REVISIONS
RETURN TO
ISSUE COPY
FOR REVIEW



Invoice

36 Colonnade Road N.
Ottawa, Ontario K2E 7J6
Tel: (613) 226-1579
Fax: (613) 226-1719

DATE	INVOICE NO.
3/31/2009	17519

BILL TO	SHIP TO
Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7	Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. NO.	TERMS	SHIP DATE	SHIPPED VIA	JOB NO.	FOB
00007972	Net 30 Days	3/31/2009	FedEx	902	Globus

QTY	DESCRIPTION
6	D36873P Mount Business Number: 102122058 <i>S. orluelos</i> <small>WE CERTIFY THAT THE ABOVE HAVE BEEN MANUFACTURED IN ACCORDANCE WITH DRAWINGS AND PURCHASE ORDER SPECIFICATIONS</small> <i>Q</i>

WHITE = Original
BLUE = C of C
YELLOW = Packing Slip

Carrying Charge - 2% per Month -24% per Annum
on Overdue Accounts



LIQUID PENETRANT TEST REPORT

P - 1369 2

PAGE 1 OF 1

CLIENT DART AEROSPACE DATE APR 8, 2009 TIME AM ☐ PM ☐
ATTENTION LINDA LACELLE ACUREN JOB NO. 188 09 1369
ADDRESS 1270 ABERDEEN ST PO/WO NO.
HAWKESBURY, ONT. WORK LOCATION HAWKESBURY
ACCEPTANCE STD. ASTM 1417/QSI-038 REV./DATE 2005
PROJECT BRACKETS AND STUDS
ITEM(S) EXAMINED JOB #'S 44684, 45911, 45912, 46052

JOB DESCRIPTION PROCEDURE NO. LT-0002 REV./DATE TECHNIQUE NO. LT-TECH2 REV./DATE
PART NO. D36873/D36871/D36873/D36911 MATERIAL THICKNESS
SCOPE WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% EXTERNAL SURFACE

TEST DETAILS

METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND	MAGNAFLUX		BLACK LGHT8171	<input checked="" type="checkbox"/> OUTPUT > 1000 μ W/CM ²	<input type="checkbox"/> AMBIENT < 2 fc
PENETRANTZL67	MINIMUM DWELL TIME	45 MIN.	LIGHTING EQUIP.	<input type="checkbox"/> FLASHLIGHT	<input type="checkbox"/> TROUBLELIGHT
PENETRANT REMOVER H2O	MINIMUM DRY TIME	>10 MIN.	OTHER	CAL JAN 24 09	
DEVELOPER SKDS2	MINIMUM DWELL TIME	10 MIN.	LIGHT METER S/N	CAL DUE DATE	
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY		

TEST SURFACE

SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/ 20°F	<input type="checkbox"/> -4°C/ 20°F TO 10°C/50°F	<input type="checkbox"/> 10°C/50°F TO 52°C/125°F	<input type="checkbox"/> > 52°C/125°F	

RESULTS- (☐ METRIC ☒ IMPERIAL)

FLUORESCENT LIQUID PENETRANT INSPECTION

CARRIED OUT ON 100% EXTERNAL

SURFACE ON:

44684- 6 BRACKETS

45911- 5 BRACKETS

45912- 4 BRACKETS

46052- 19 STUDS


RESULTS: NO INDICATION OF DEFECTS.

ITEMS ACCEPTABLE TO STANDARD

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner operator and the owner operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE	DTR # E 27430	
TECHNICIAN (SIGNATURE): 	SIGNATURE	REPORT REVIEWED BY:
NAME (PRINT): JASON HEWETT	1 ST TECHNICIAN	NAME INITIALS
CGSB LEVEL 2 SNT LEVEL	CGSB LEVEL SNT LEVEL	
CGSB REG. NO 6156	CGSB REG. NO	

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY